

ABSTRACT

A technique is presented for preventing the peeling of a thermally sprayed film formed on an inner face of a bore of a cylinder block. A thermal spraying device 20 is provided with: a thermal spraying gun 22 that is inserted into a bore 14 passing through a cylinder block 12; and a pair of sucking pipes 24a,24b 24 for generating a spiraling air current 28 that spirals around an axis of the bore 14 while approaching an opening of this bore 14.

The spiraling air current 28 creates a flow of vapors towards the center of the bore 14. Creating the flow towards the center of the bore 14 causes fumes contained among particles to gather at the center of the bore 14. The fumes gathered at the center of the bore 14 are carried by the spiraling air current 28 towards the opening of the bore 14, and are sucked out of the bore 14. As a result, a high-quality thermally sprayed film scarcely containing fumes can be formed on the inner face of the bore 14.